



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-2708-01-15

Job Sheet 193362



Part No: RBE350A94-2708-01-15

Job Qty: 10 pcs

Part Name: Rod Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/12/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A94-2708-01 Rev G IPP Rev A 18.01.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	10 pcs	5/6/19	0.00	2.00		External Load - 1		<i>Dart / MK</i>
							External Load - 2		
							External Load - 3		
							Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	10 pcs	5/6/19	0.00	0.00		QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
121	Outsource - 12 - Black Oxide	10 pcs	5/6/19				QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							GRO002-VC	10	
							Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
122	Packaging 2-1 - Receive - B4B	10 pcs	5/6/19				Packaging 2 - 3 - B4B		



Container No: S187417



Part: RBE350A94 - 2708 - 01 - 15

Job No: 193362

Serial No/Batch: S187417

Revision: G

Inspector:

Exp Date:

Instructions:

Date: 06/04/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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					Packaging 2 - 5 - B4B	 JUN 17 2019					
					Packaging 2 - 4 - B4B						
					Packaging 2 - 6 - B4B						
					Packaging 2 - 7 - B4B						
					Packaging 2 - 8 - B4B						
					Packaging 2 - 9 - B4B						
					Packaging 2 - 10 - B4B						
					Packaging 2 - 11 - B4B						
					Packaging 2 - 12 - B4B						
					Packaging 2 - 13 - B4B						
					Packaging 2 - 14 - B4B						
					Packaging 2 - 15 - B4B						
					Packaging 2 - 16 - B4B						
					Packaging 2 - 17 - B4B						
					Packaging 2 - 18 - B4B						
					Packaging 2 - 19 - B4B						
					Packaging 2 - 20 - B4B						
					Packaging 2 - 21 - B4B						
					Packaging 2 - 22 - B4B						
					Packaging 2 - 23 - B4B						
					Packaging 2 - 24 - B4B						
					Packaging 2 - 25 - B4B						
					Packaging 2 - 26 - B4B						
					Packaging 2 - 27 - B4B						
					Packaging 2 - 28 - B4B						
					Packaging 2 - 29 - B4B						
					Packaging 2 - 30 - B4B						
					Packaging 2 - 31 - B4B						
					Packaging 2 - 32 - B4B						
					Packaging 2 - 33 - B4B						
					Packaging 2 - 34 - B4B						
					Packaging 2 - 35 - B4B						
					Packaging 2 - 36 - B4B						
					123 QC 6		10 pcs	5/6/19	0.00 0.00	QC 6 - 9	JUN 17 2019 DAS 40 9-89
										QC 6 - 68	
										QC 6 - 61	
130 Packaging 3-1 - Stock - B4B	10 pcs	5/6/19	0.00 0.00	Packaging 3 - 1 - B4B							
				Packaging 3 - 2 - B4B							
				Packaging 3 - 3 - B4B							
				Packaging 3 - 4 - B4B							
				Packaging 3 - 5 - B4B							
				Packaging 3 - 6 - B4B							
				Packaging 3 - 7 - B4B							
				Packaging 3 - 8 - B4B							
				Packaging 3 - 9 - B4B							
				Packaging 3 - 10 - B4B							
				Packaging 3 - 11 - B4B							
				Packaging 3 - 12 - B4B							
				Packaging 3 - 13 - B4B							
				Packaging 3 - 14 - B4B							
				Packaging 3 - 15 - B4B							
				Packaging 3 - 16 - B4B							
				Packaging 3 - 17 - B4B							
				Packaging 3 - 18 - B4B							
				Packaging 3 - 19 - B4B							
				Packaging 3 - 20 - B4B							
				Packaging 3 - 21 - B4B							
				Packaging 3 - 22 - B4B							
				Packaging 3 - 23 - B4B							
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				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	10 pcs	5/6/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - (Small Fab) -Press fit -05 into -03 as per DWG. Sheet 3

Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)

121 - -Issue P/O; 43671 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required

122 - (Receive & Inspect for Damage & Mat'l Certs) Receive

123 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98381A593 <u>GA042</u>	Dowel Pin	10 Ea (1 ea)	110-Small Fab - 1	<u>S180875</u>
RBE350A94-2708-01-03 <u>WARB-07</u>	Rod	10 pcs (1 ea)	110-Small Fab - 1	<u>S135472</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	98381A593	10	19	0
	RBE350A94-2708-01-03	10	10	0

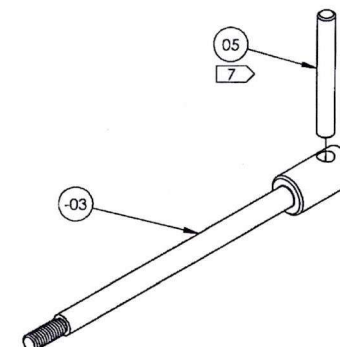
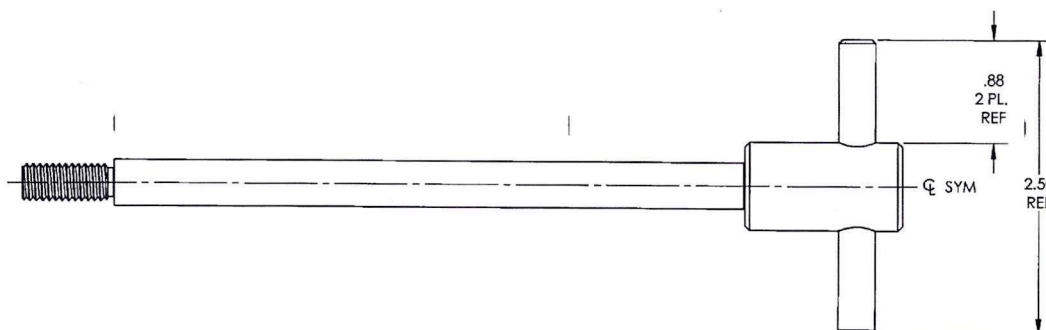
Part Specifications

Specifications could not be found.

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ITEM #	QTY	PART #	TITLE	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-03	1	RBE350A94-2708-01-03	ROD	G	ASSY ADDED	17-804	01/02/2018	VM	ML
05	1	McMaster#98381A593	DOWEL PIN 5/16" x 2-1/2" LG.						

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193363 MW
19-04-72



RBE350A94-2708-01-15 ROD ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE (NEUTRALIZE AFTER BLACK OXIDE TREATMENT)
- 4) SPEC: MIL-C13924, CLASS 1; MIL-C-16173 GRADE 4
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) PRESS DOWEL INTO ROD

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE ROD ASSY	
PART NO. RBE350A94-2708-01-15	REV G
TOOL NO. RBE350A94-2708-01	
INITIALS AND DATE	
DESIGNED BY: VM 01/02/2018	TOLERANCES: XXX ± .005
DRAWN BY: VM 01/02/2018	XX ± .01
CHECKED BY: VM 01/02/2018	X ± .1
MFG REVIEW BY: DD 01/03/2018	APPROVED BY: ML 01/08/2018
SCALE: NTS	
SHEET 3 OF 4	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043671



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043671

PO Date: 6/7/19

Due Date: 6/14/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-06-10

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193899	RBD29932-1	Puller Nut -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	6/14/19	4 pcs	0 pcs	4 pcs	\$9.00/pcs	\$36.00
2	195092	RBE350A93-3712-00-21	Centering Pin -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	6/14/19	6 pcs	0 pcs	6 pcs	\$1.19/pcs	\$7.14



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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	193362	RBE350A94-2708-01-15	Rod Assembly -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	6/14/19	10 pcs	0 pcs	10 pcs	\$4.85/pcs	\$48.50
							10 X	JUN 17 2019			
4	193931	RBE1X56-137-180-3	Plate -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	6/14/19	6 pcs	0 pcs	6 pcs	\$4.95/pcs	\$29.70
							6 X	JUN 17 2019			
5	194687	RBA8100-80902-201	Wrench -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	6/14/19	3 pcs	0 pcs	3 pcs	\$3.15/pcs	\$9.45
							3 X	JUN 17 2019			
6	193415	RBE350A94-3700-C-09	Knurled Nut -Issue P/O; _____ PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	6/14/19	24 pcs	0 pcs	24 pcs	\$0.95/pcs	\$22.80
							24 X	JUN 17 2019			

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Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043671



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:											\$153.59

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

[Handwritten signature]
10-06-19

Plex 6/10/19 10:31 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(019877-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

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Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
14-Jun-2019		SVETLANA DORZHIYEVA		POHB043671 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBD29932-1 ✓ Rev.	RBD29932-1 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	OXIDE-BLACK CH	4	4 ✓	0	0	0
2	RBE350A93-3712-00-21 ✓ Rev.	RBE350A93-3712-00-21 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	OXIDE-BLACK CH	6	6 ✓	0	0	0
3	RBE350A94-2708-01-15 ✓ Rev.	RBE350A94-2708-01-15 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	OXIDE-BLACK CH	10	10 ✓	0	0	0
4	RBE1X56-137-180-3 ✓ Rev.	RBE1X56-137-180-3 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	OXIDE-BLACK CH	6	6 ✓	0	0	0
5	RBA8100-80902-201 ✓ Rev.	RBA8100-80902-201 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OF EXCESS	OXIDE-BLACK CH	3	3 ✓	0	0	0
6	RBE350A94-3700-C-09 ✓ Rev.	RBE350A94-3700-C-09 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	24	24 ✓	0	0	0

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JUN 14 2019

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Livré à / Ship to

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1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

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 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
14-Jun-2019		SVETLANA DORZHIYEVA		POHB043671				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order

Notes Additionnelles / Additional Notes

SMALL BOXES

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.